

1/17

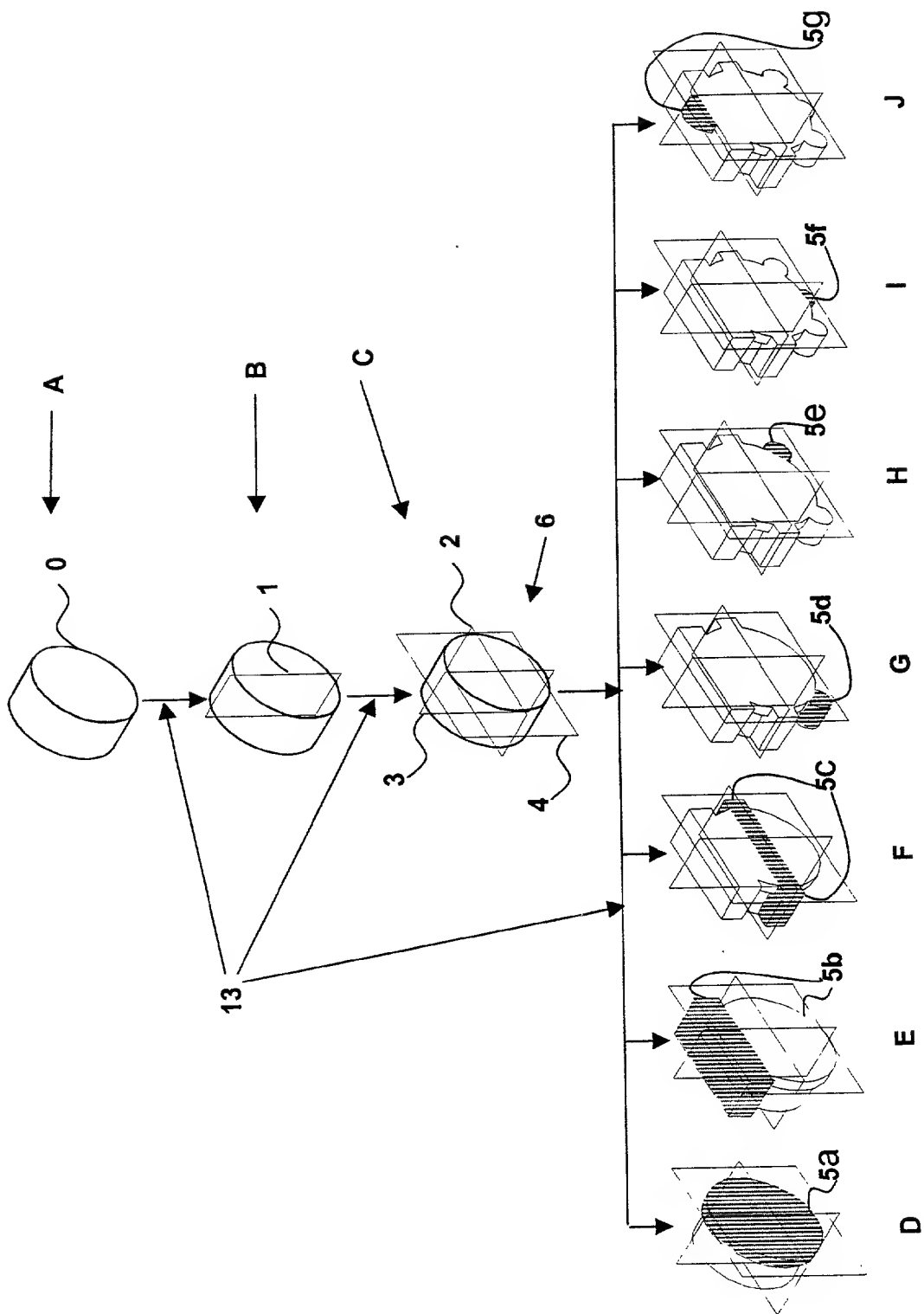


FIG. 1

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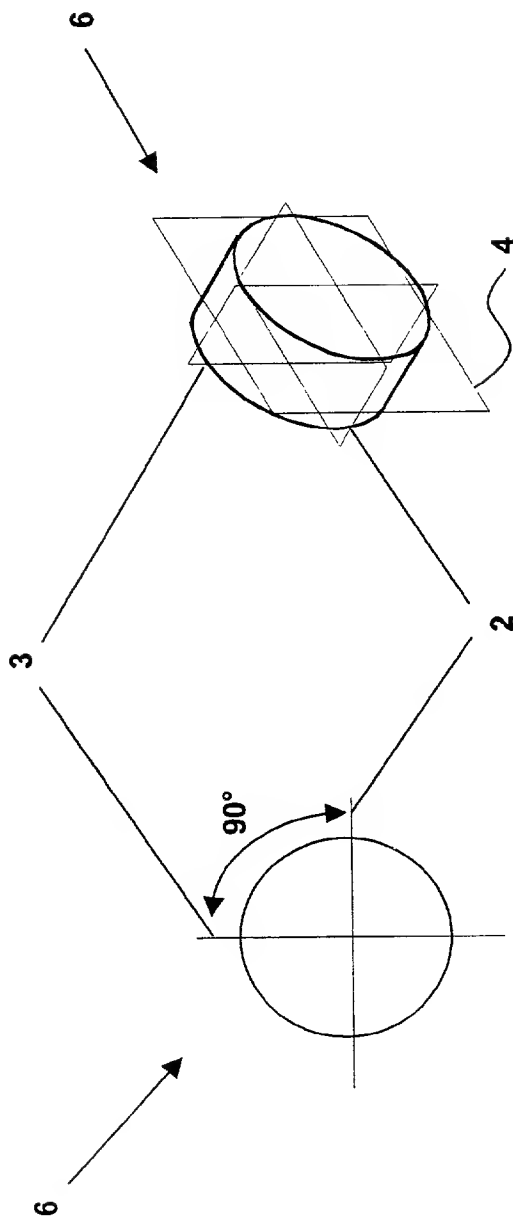


FIG. 2

TOP SECRET

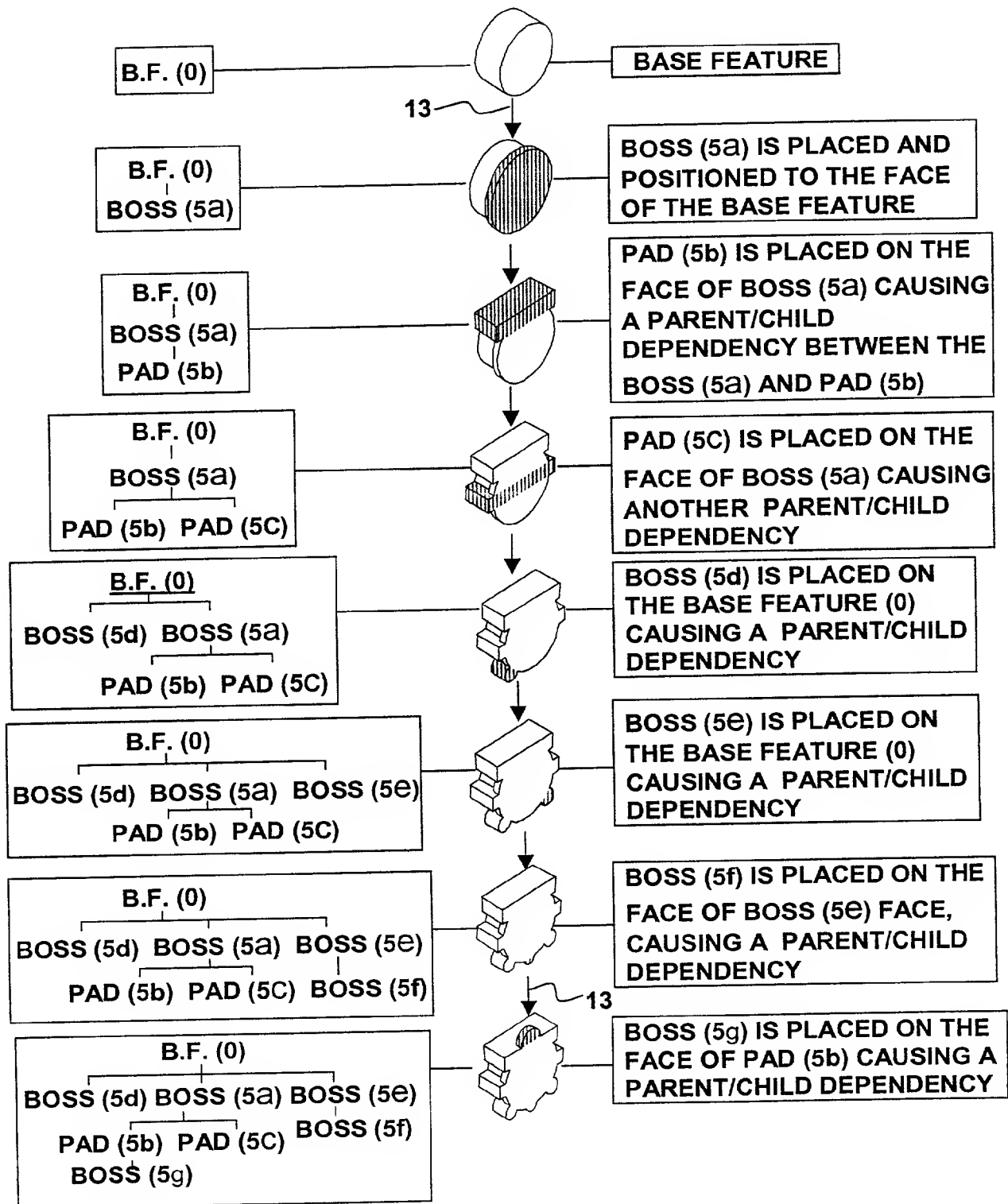


FIG. 3

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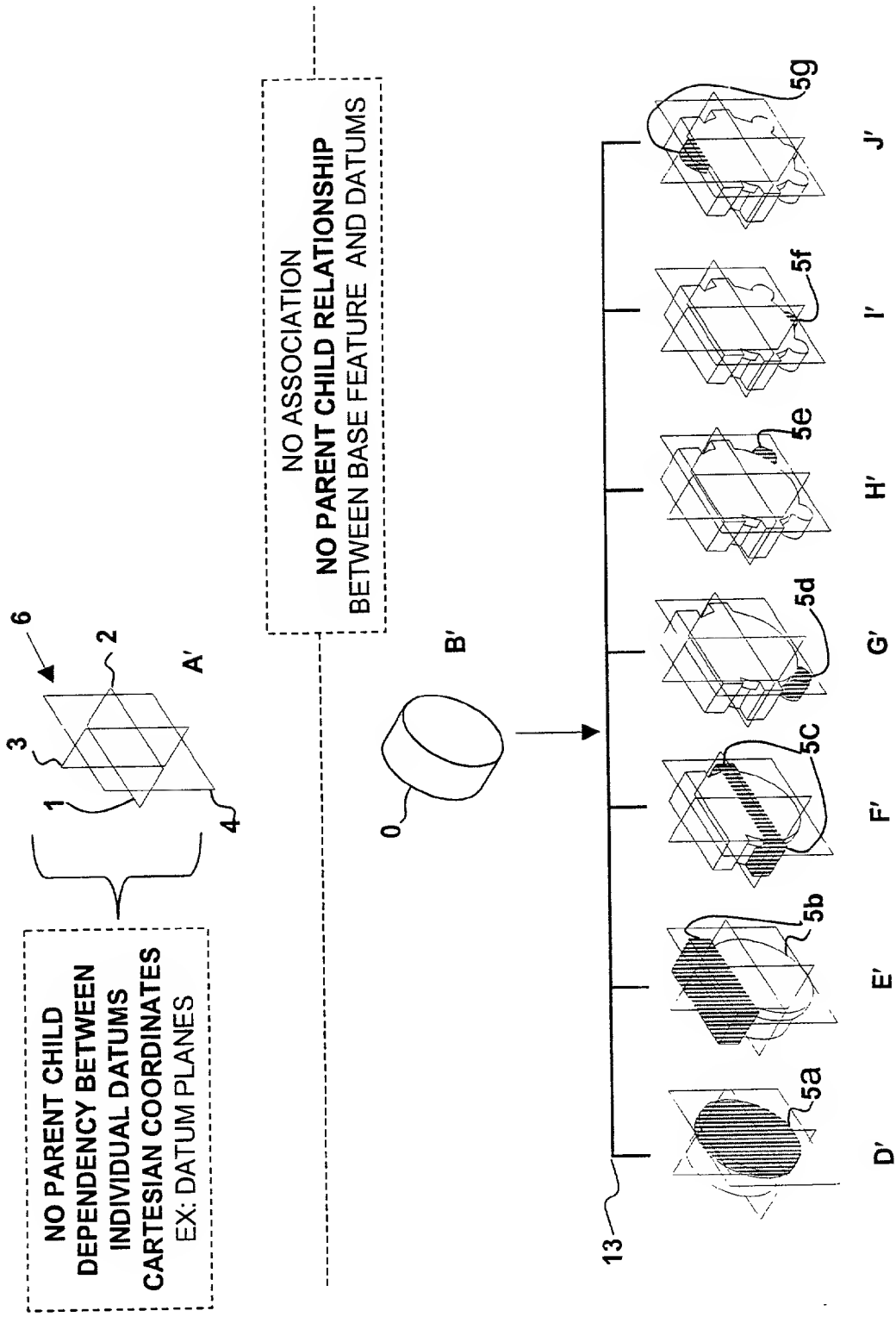


FIG. 4

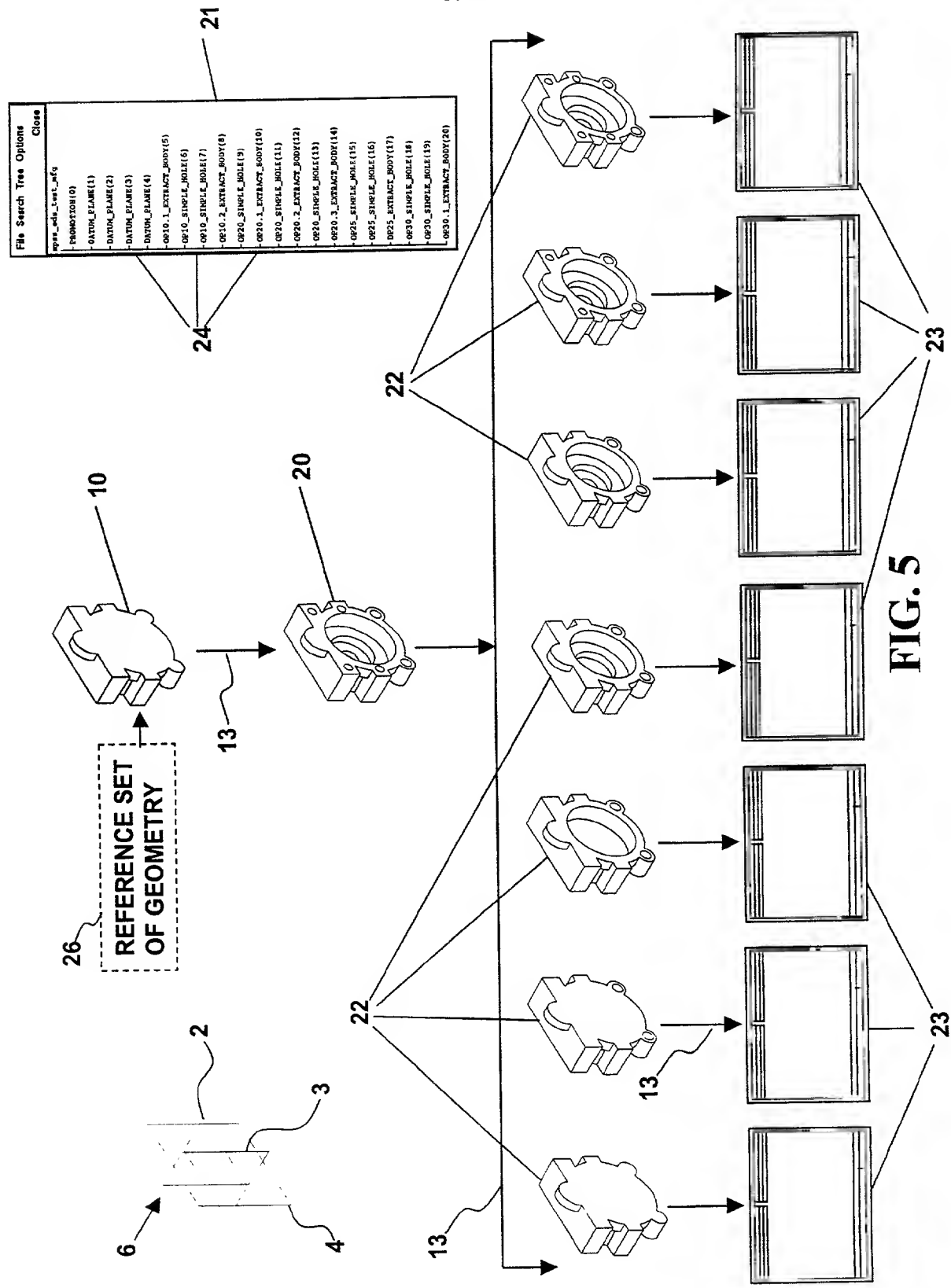


FIG. 5



FIG. 6

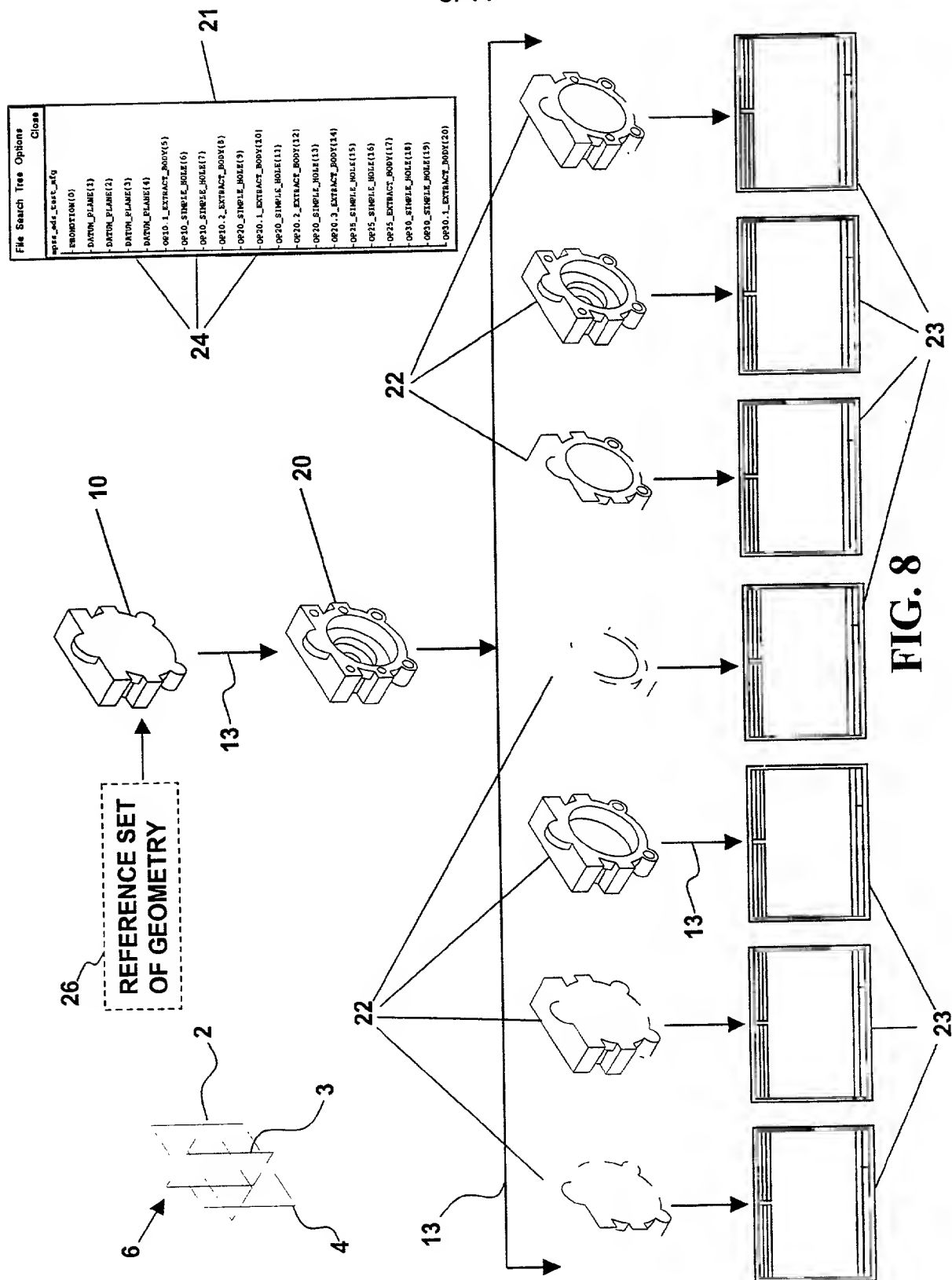
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[illegible]

FIG. 7

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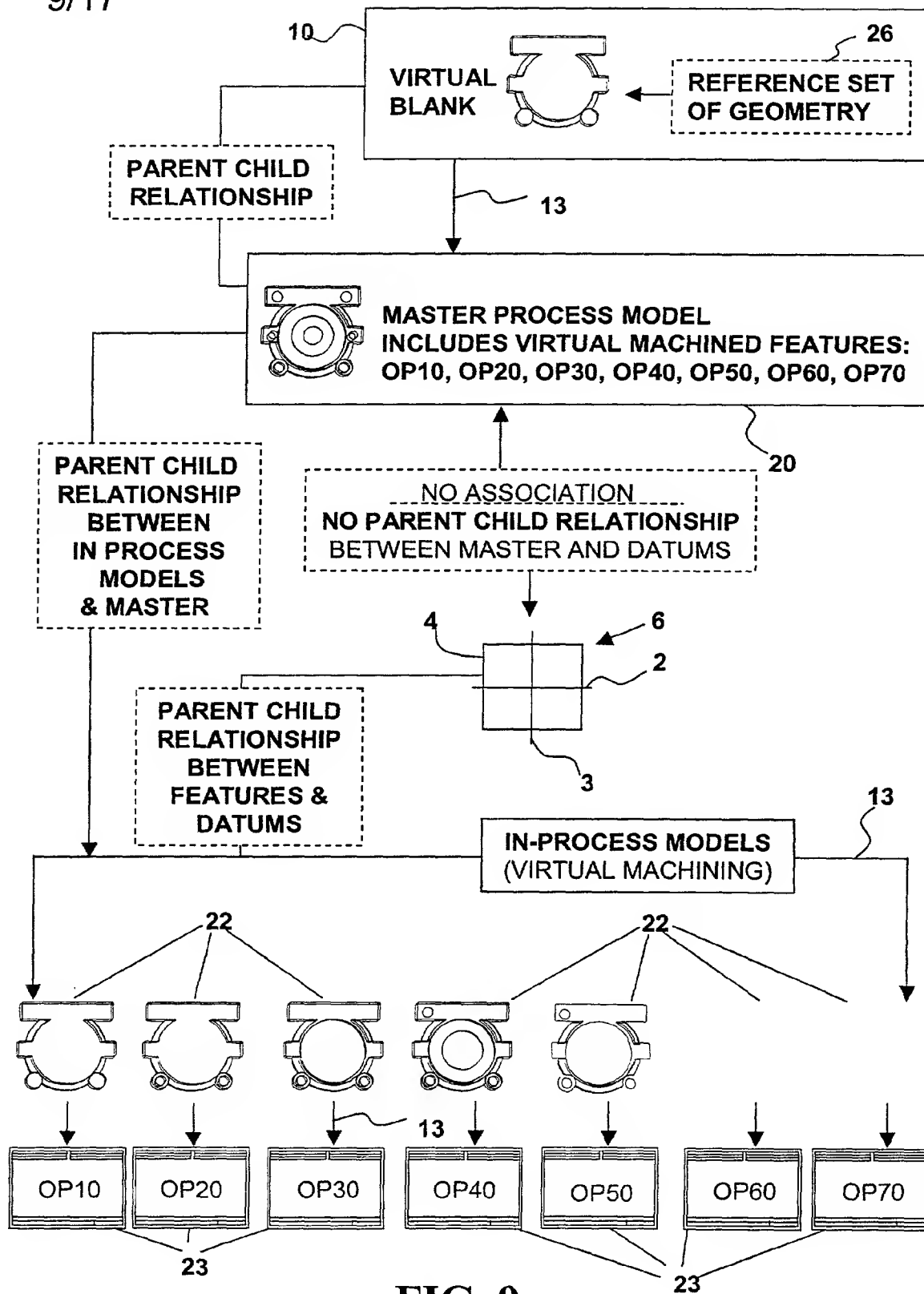


FIG. 9

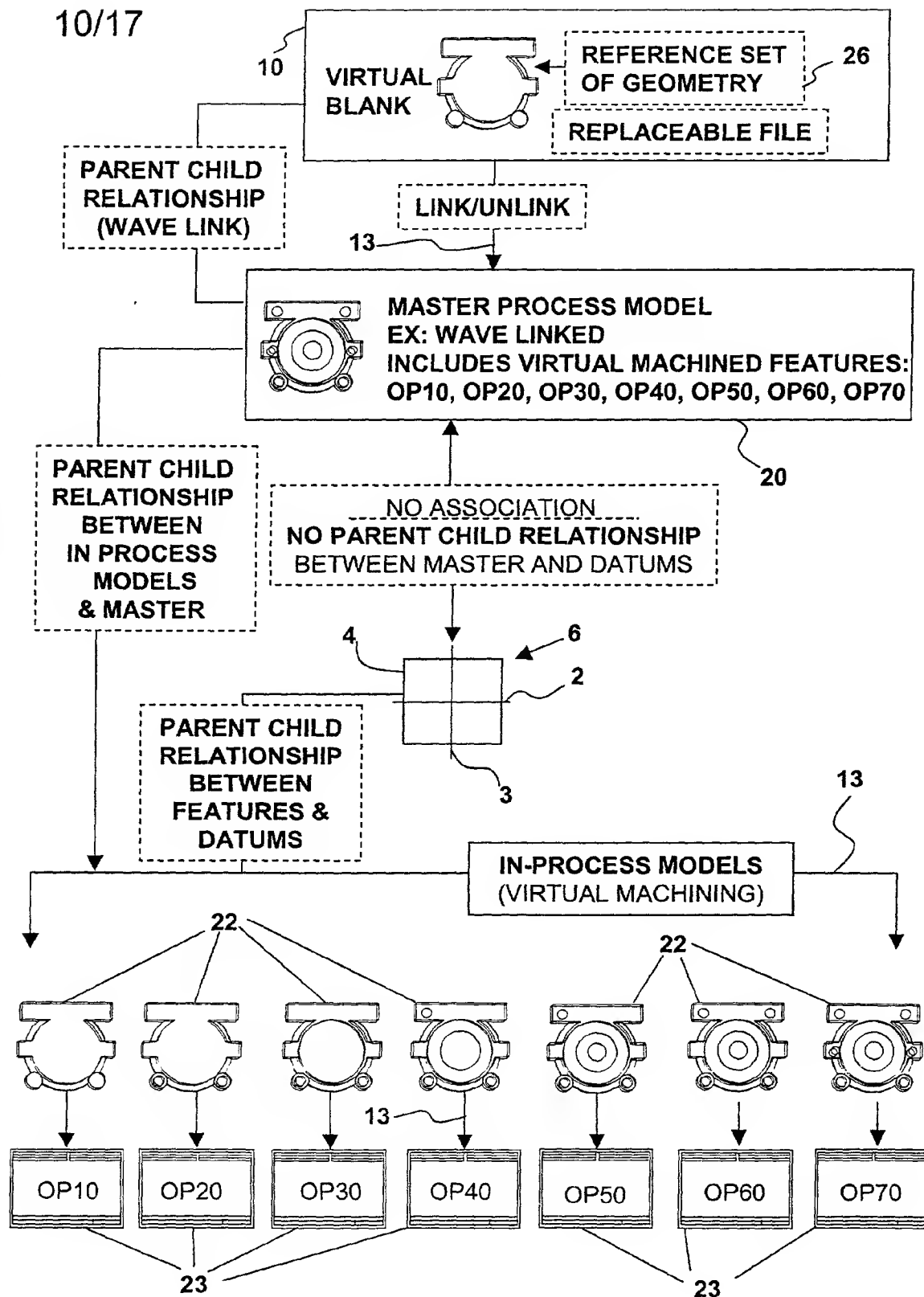


FIG. 10

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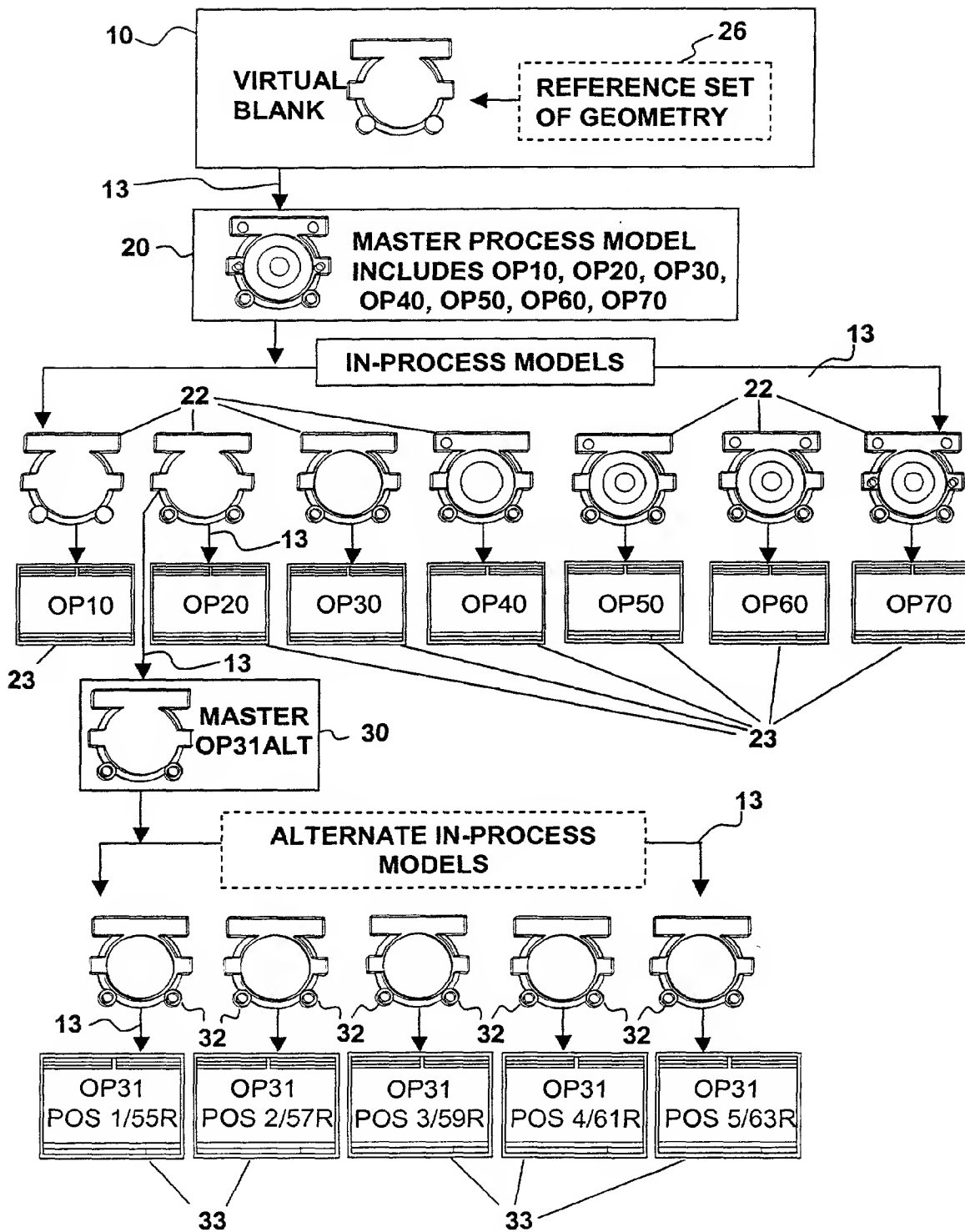
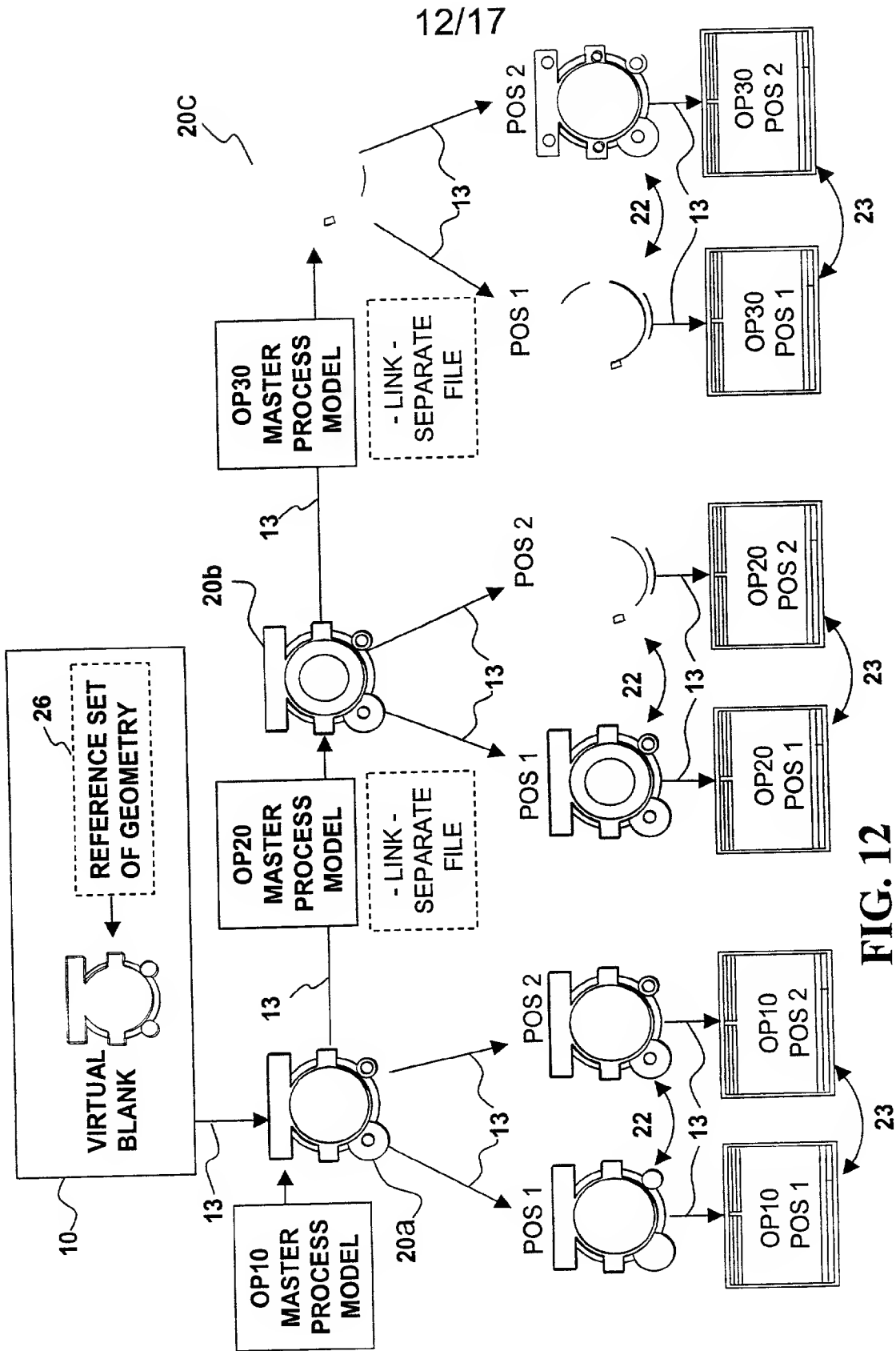


FIG. 11



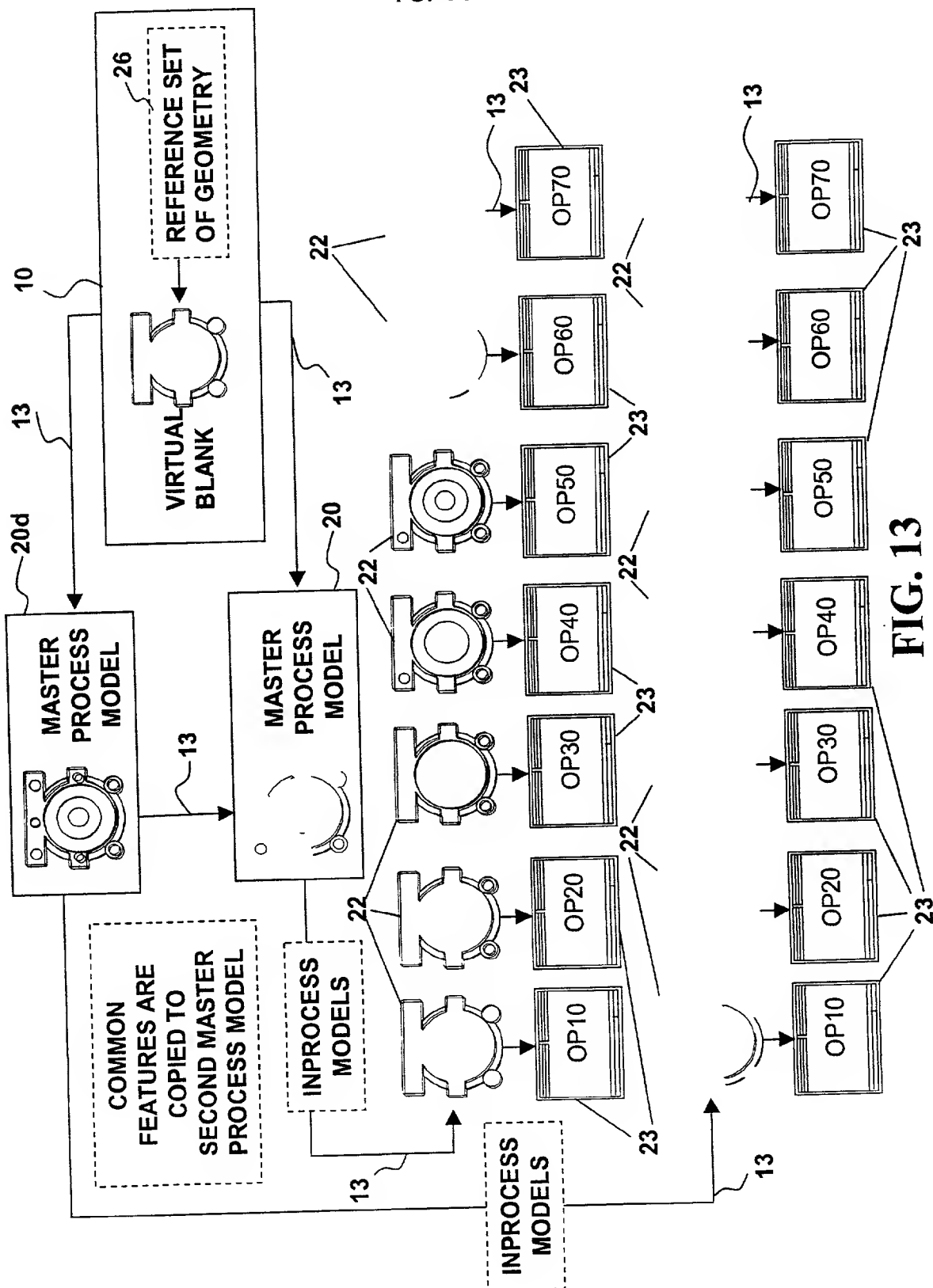


FIG. 13

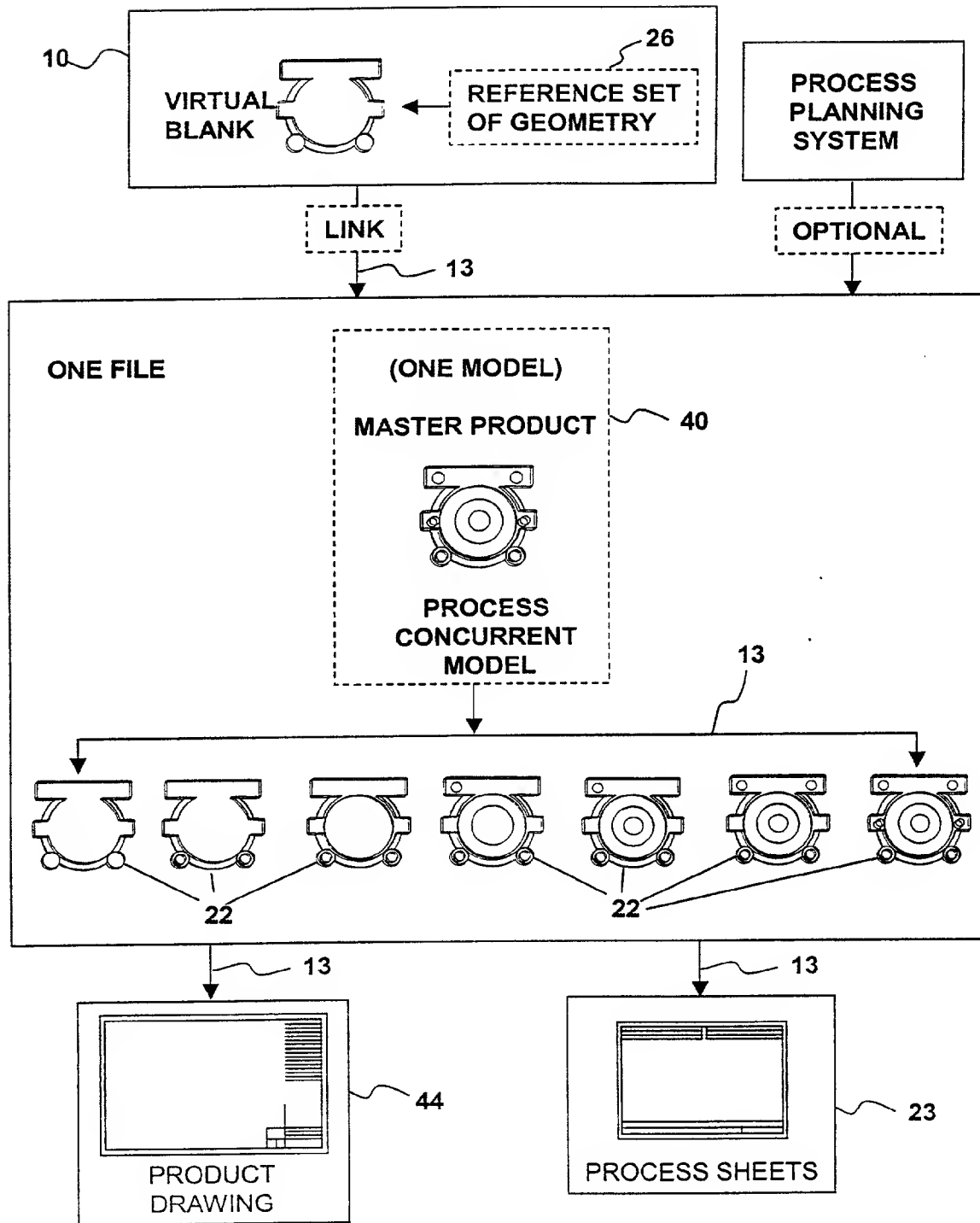


FIG. 14

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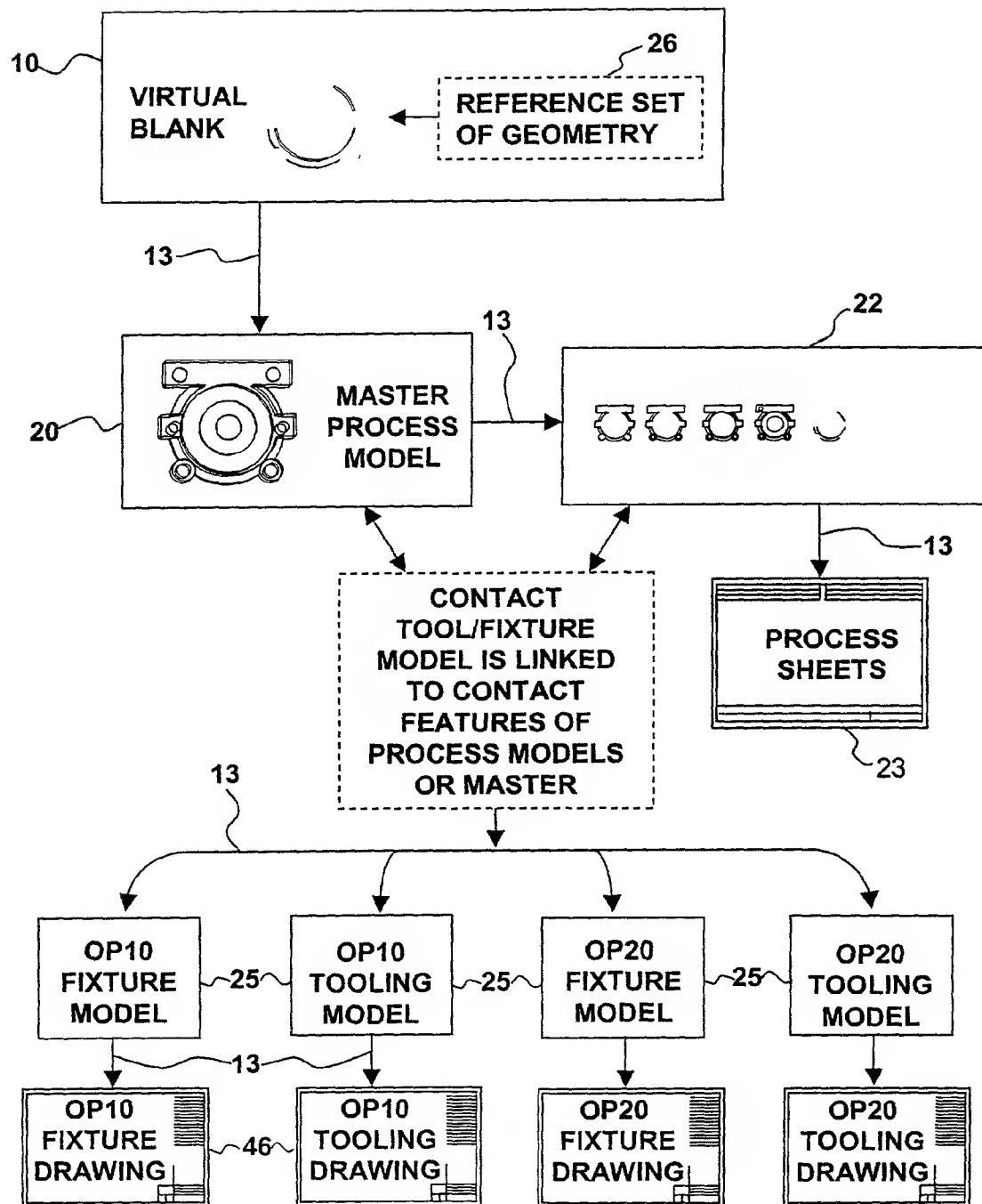


FIG. 15

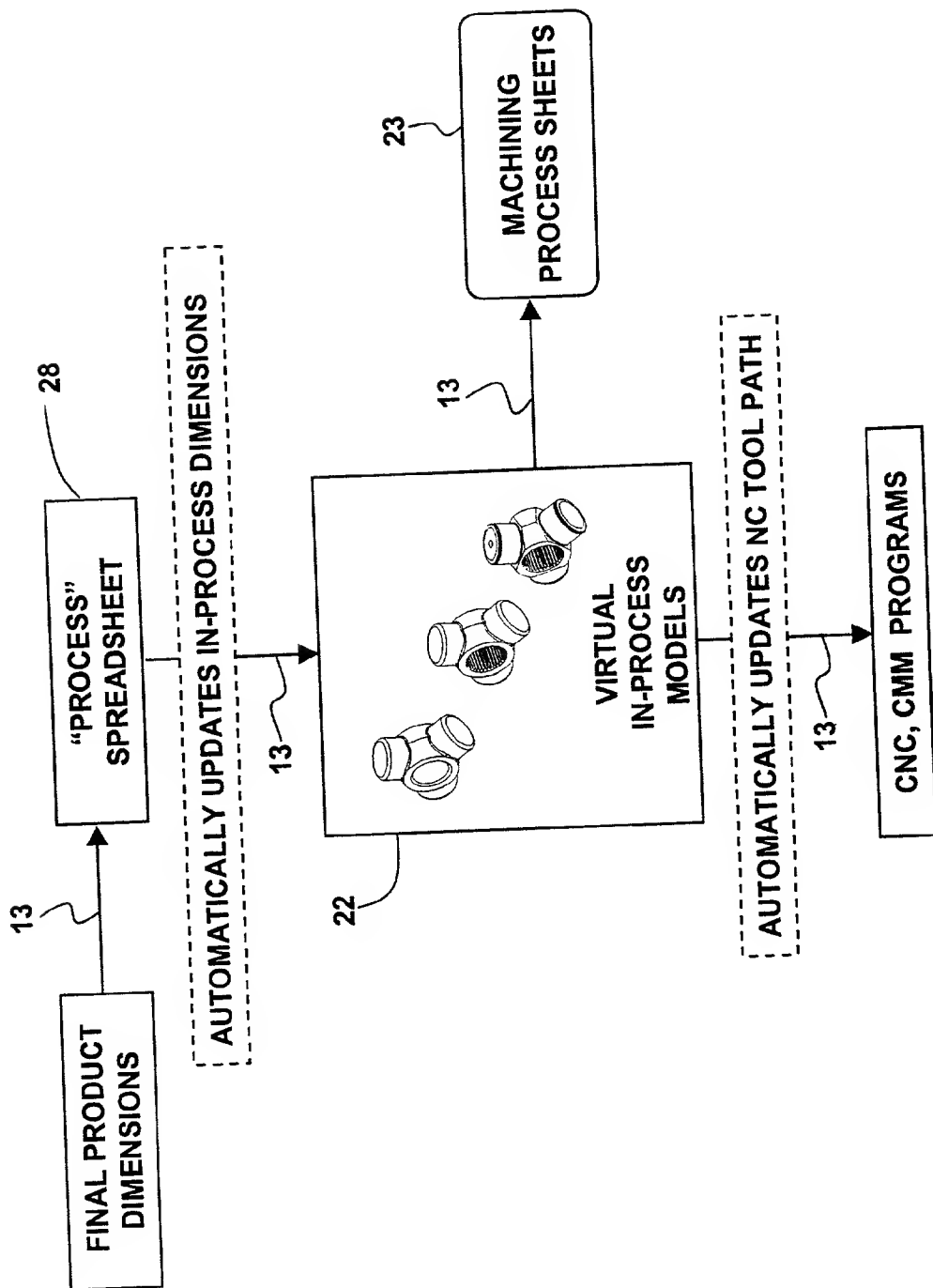


FIG. 16

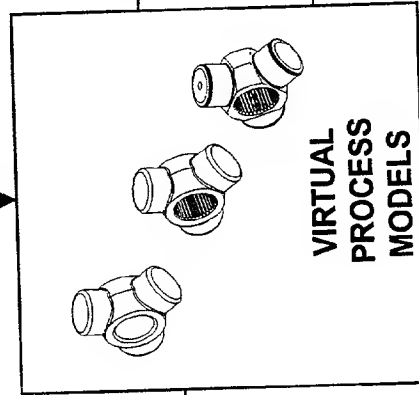
FINAL PRODUCT
DIMENSIONS

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BLUE: FINAL PRODUCT DIMENSIONS		YELLOW HILITE: PROCESS RULE	
RED: CALCULATED IN-PROCESS DIMENSIONS BASED ON PROCESS RULES			
Operations	Part	Description	Parameters
Operation 11/13/14 Bore and Chamfer		Max Broached hole diameter after HT	max_broach_hole_dia
		Min Broached hole diameter after HT	min_broach_hole_dia
		Heat treat distortion	htd_broach
		Max minor diameter if Broached hole before HT	max_minor_dia
		Min minor diameter of Broached hole before HT	min_minor_dia
		Minimum recommended stock removal(broach)	min_stk_rem
		Maximum recommended stock removal (broach)	max_stk_rem
		Maximum Bored hole diameter	max_hole_dia
		Minimum Bored hole diameter	min_hole_dia
		Average Bored hole diameter	avg_hole_dia
			26.433
			26.353
			0.08
			26.493
			26.413
			0.203
			0.393
			26.21
			26.1
			26.155

AUTOMATICALLY UPDATES IN-PROCESS DIMENSIONS

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MACHINING
PROCESS SHEETS

CNC,CMM
PROGRAMS

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FIG. 17